

Table 1

Ex. No. Components	Comp.	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
		%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%	%
Rosin (KE604) ^a	40	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35	35
TPNB ^b	54	54	54	54	54	54	54	54	54	54	54	54	54	54	54	58	58	58	39
Styrene dibromide	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
Thixatrol ^c	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
Isocarb 24 ^d	5													2.5	4	1	20		
Isocarb 36 ^e			5											2.5	1		1	20	
Isocarb ester 1605 ^f				5															
Kristol T60 ^g					5														
Panacera MW ^h						5													
Iso stearic acid							5												
Stearic acid								5											
Palmitic acid									5										
Micronised PTPE ⁱ										5									
200/100CS ^j											5								
Dow Corning 704 ^k												5							
Isodol 24 ^l													5						

^a Rosin (KE604) available from Arakawa is an acid modified hydrogenated rosin. ^b TPNB available from Dow is tri(propylene glycol) butyl ether. ^c Thixatrol + available from Rheox is a rheological additive. ^d Isocarb 24 available from Condea is 2-decyltetradecanoic acid.

^e Isocarb 36 available from Condea is 2-hexadecyltetradecanoic acid.

^f Isocarb ester 1605 available from Condea is 2-hexadecyltetradecanoic acid-pentaerythritol ester.

^g Kristol T60 available from Carless is mineral oil. ^h Panacera MW available from Industrial Waxes Ltd is paraffin wax.

ⁱ Micronised PTPE available from Ranc Ltd is PTPE micropowder. ^j 200/100CS available from Dow Corning is polydimethylsiloxane.

^k Dow Corning 704 available from Dow Corning is Tetramethyltetra-phenyltrisiloxane and pentaphenyltri-methyltrisiloxane.

^l Isodol 24 available from Condea is 2-decyltetradecanol.

FIG. 2

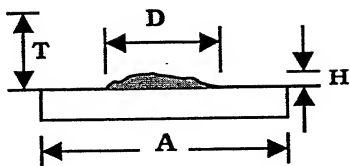


FIG. 3

Table 2

SCORE	DESCRIPTION	VALUES
1	No paste or almost no paste	$D < \frac{1}{2}A$ $H < \frac{2}{3}T$
2	More than $\frac{1}{2}$ of pad area covered but insufficient height	$D < \frac{1}{2}A$ $H < \frac{2}{3}T$
3	More than $\frac{2}{3}$ pad area covered, paste reaches same height as stencil	$D < \frac{2}{3}A$ $H = T$ for $< \frac{1}{3}A$
4	More than $\frac{2}{3}$ pad area covered and diameter of top is $> \frac{1}{3}$ of aperture	$D < \frac{2}{3}A$ $H = T$ for $< \frac{1}{2}A$
5	Perfect deposit, same shape as stencil aperture	$D = A$ $H = T$ for $> \frac{2}{3}A$

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FIG. 4

TABLE 3

Example	Additive (%)	Score
Comparative	None	2
1	Isocarb 24	3
2	Isocarb 36	5
3	Isocarb ester 1605	4
4	Kristol T60	4
5	Pancera MW	4
6	Iso stearic acid	4
7	Stearic acid	3
8	Palmitic acid	4
9	Micronised PTFE	3
10	200/100cS	3
11	Dow Corning 704	3
12	Isofol 24	4
13	Isocarb 24 (2.5) / Isocarb ester 1605 (2.5)	4
14	Isocarb 24 (4) / Isocarb ester 1605 (1)	3
15	Isocarb 24 (1)	3
16	Isocarb 24 (20)	4
17	Isocarb ester 1605 (1)	3
18	Isocarb ester 1605 (20)	3